

Work Order ID 111184

January-09-14 12:39:25 PM

111184

Rev E Serial 124

Page 1

Item ID: D4635-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Ceiling Panel Assembly, LH

Stop

NS2

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *MS*

Date: *14-01-09*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	<i>PD2 E Wh.</i>	DAS 27 9-89							
100	<i>DET Rn E</i>	<i>per ECU 14-509</i>							
100		0.00							
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								
110		0.00							
110		0.00							
Small Fab	Memo								
Small Fab	1- Assemble as per Dwg D4635-043								
	2-Install speaker								
	3- Install Air valve								
	4-Install Wiring Harness								
	5-Install wiring harness								

Y1

14/01/23

Y1

14/01/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111184

January-09-14 12:39:25 PM

111184

Page 2

Item ID: D4635-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Ceiling Panel Assembly, LH
 Start Date: 09/01/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 24/01/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC - Inspect dimensions to drawing <i>5 on</i> Memo	0.00 27 3-89 0.00 14/1/23				1			<i>Inspected as per Dwg Rev PE1</i>
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<i>Thermo</i> <i>MC5</i>
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>MC5 14-01-24</i> <i>on 14/01/24</i>

POSITIVE RECALL
 EFFECTIVE 7/4/06/24 AUTH: *LL*
 RELEASED *S* DATE 14/01/24

DAS
 27
 9-89

14/1/23

*Red Done Dwg
 Rev F*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

Thursday, January 23, 2014 8:28:47 AM

Page 1

Work Order ID: 111184

Parent Item: D4635-043

Parent Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
DL IPP Rev C Dwg. Update 13/07/09 DL verf:DD
Rev D Dwg Update 14/01/20 DL IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-143 Aft Ceiling Replacement Panel Assembly, LH		Manufactured	No			100	Each	2.0000	1	1			DL 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		2							
				111206		1							
				111209		1							
D4646-1 Plenum Cap Assembly		Manufactured	No			100	Each	84.0000	1	1			DL 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		84							
				103832		66							
				92968		6							
				95779		12							
D4652-1 Air Valve, 1.16 Id Disk Type		Manufactured	No			100	Each	215.0000	1	1			DL 24/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		24							
				111316		12							
				111317		12							
				ST099		191							
				111311		191							
D4655-1 Speaker		Manufactured	No			100	Each	90.0000	1	1			DL 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST478		48							
				103939		48							
				ST483		42							
				93061		42							

Picklist Print

Thursday, January 23, 2014 8:28:47 AM

Page 2

Work Order ID: 111184

Parent Item: D4635-043

Parent Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4708-9
Lanyard

Manufactured No

100 Each 55.0000 1 1

Location	Loc Qty	Loc Code
ST119	55	
111242	49	
93919	6	

14/01/23

D4728-045
LH Cabin Speaker #3

Manufactured No

100 Each 1.0000 1 1

Location	Loc Qty	Loc Code
ST121	1	
96243	1	

14/01/23

D4728-061
Cabin Lights Control Relay

Manufactured No

100 Each 1.0000 1 1

Location	Loc Qty	Loc Code
ST121	1	
96170	1	

14/01/23

D4743-1
Speaker Grill

Manufactured No

100 Each 30.0000 1 1

Location	Loc Qty	Loc Code
ST122	30	
111220	30	

14/01/23

MS21044-N08
Nut

Purchased No

100 Each 265.0000 4 4

Location	Loc Qty	Loc Code
ST315	265	
123741	115	
m127813	150	

14/01/23

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Shop Packet Print

Page 2

Picklist Print

Thursday, January 23, 2014 8:28:47 AM

Page 3

Work Order ID: 111184

Parent Item: D4635-043

Parent Item Name: Aft Ceiling Panel Assembly, LH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG8

Purchased

No

100

Each

82.0000

3

3

Clamp

Location

Loc Qty

Loc Code

ST322

82

m127305

12

m127831

40

m127916

30

14/01/23

MS24693-BB51

Purchased

No

100

Each

528.0000

4

4

Screw

Location

Loc Qty

Loc Code

ST299

528

124704

28

m127916

500

14/01/23

NAS1149DN832J

Purchased

No

100

Each

3,136.0000

4

4

Washer

Location

Loc Qty

Loc Code

ST293

1000

M127813

1000

st510

376

124555

376

ST510a

1760

M126319

760

M127255

1000

14/01/23

PLT1.5M-M

Purchased

No

100

Each

1,008.0000

3

3

Tie Wrap

Location

Loc Qty

Loc Code

ST389

1008

124363

8

m126551

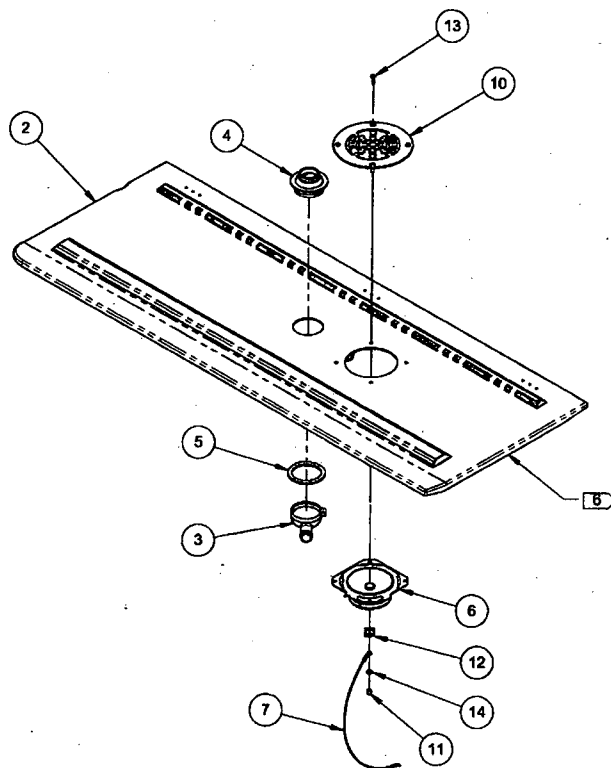
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14/01/23

Thursday, January 23, 2014 8:28:48 AM

Shop Packet Print

Page 3



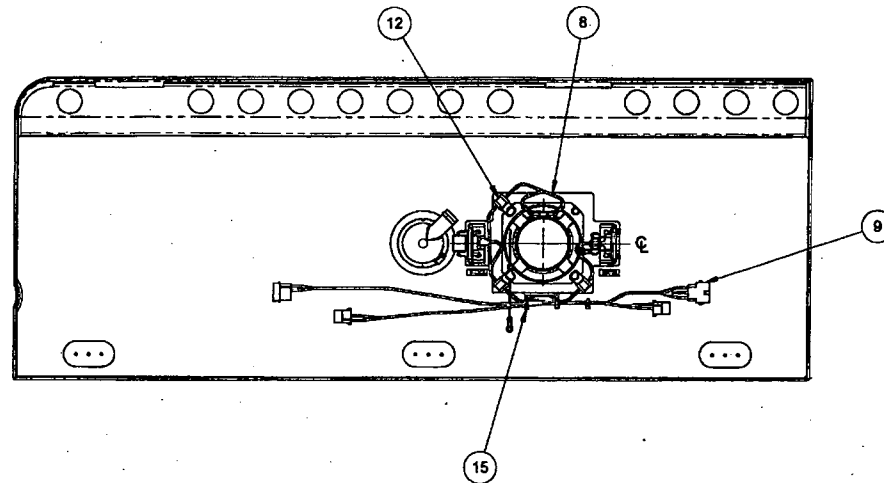
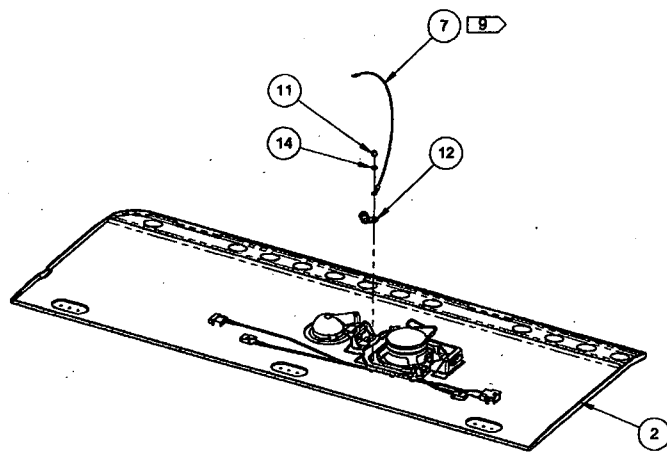
D4635-043 LH, AFT CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 5.0 lbs
- 8) INSTALL D4728-045/-061 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO $\phi 0.198$ BOTH ENDS

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4635-043	LH, AFT CEILING PANEL ASSY
2	1	D4635-143	LH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-045	LH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4728-061	CABIN LIGHTS CONTROL RELAY HARNESS ASSEMBLY
10	1	D4743-1	SPEAKER GRILL
11	4	MS21044-N08	NUT
12	3	MS21919WDG8	CLAMP
13	4	MS24693-BB51	SCREW
14	4	NAS1149DN832J	WASHER
15	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

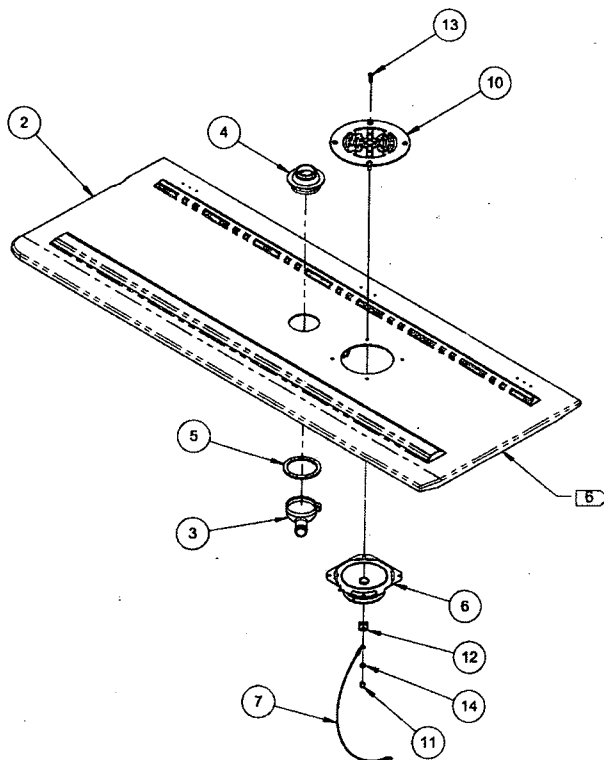
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4635	SHEET 5 OF 18
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	OUTBOARD CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4635-043 LH, AFT CEILING PANEL ASSY
AUXILIARY VIEW

14.01.09 22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D4635	SHEET 8 OF 18
APPROVED	RF	TITLE	SCALE
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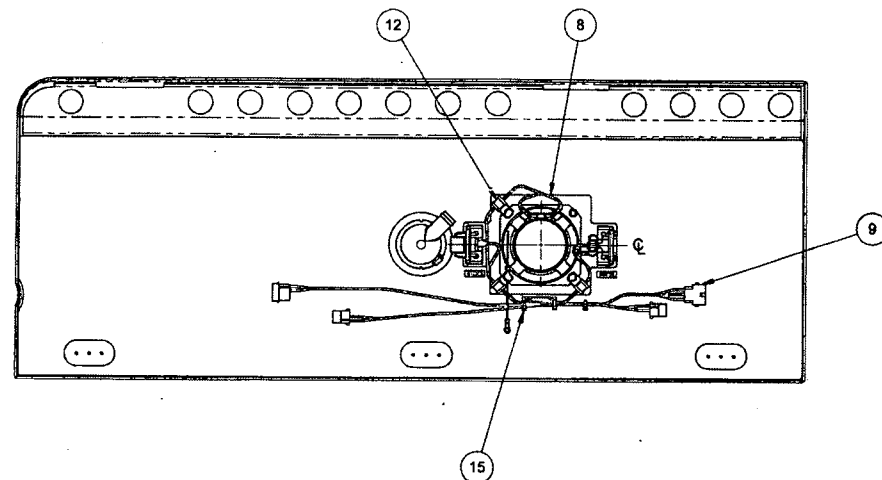
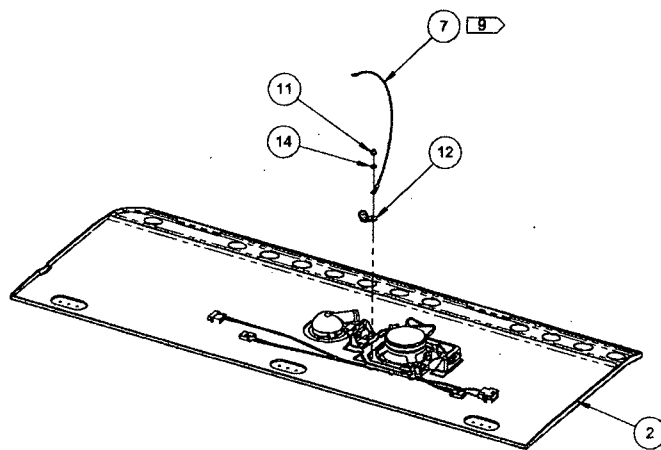
D4635-043 LH, AFT CEILING PANEL ASSY

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13	4	MS24693-BB51	SCREW
14	4	NAS1149DN832J	WASHER
15	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4635	SHEET 5 OF 18
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D4635-043 LH, AFT CEILING PANEL ASSY
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4635	SHEET 6 OF 18
APPROVED	BC	TITLE	SCALE
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